

Date: Tuesday, 15/07/2008 9:13:59 AM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: FLOOR PROTCTOR AFT LH		
Job Number	40474			Part Number	: D32813		
Estimate Number	11228			Drawing Number	: D3281 REV. D		
P.O. Number	:			Project Number	: N/A		
This Issue	15/07/2008	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	THERMOFORMING	Due Date	21/07/2008	Qty:	10 Um: Each
Previous Run	39996						
Written By	:						
Checked & Approved By	<u>JUL 08.15.08</u>						
Comment	Est Rev:A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL Est Rev. C 08.02.06 To reflect updated Dwg. DL Est Rev. D 08.04.15 Material Change DL						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description.:
1.0	MLEXS093F600602	GE PLASTICS LEXAN SHEET
 Comment: Qty.: 4.3330 sf(s)/Unit Total : 43.3300 sf(s) GE PLASTICS LEXAN SHEET		
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
 Comment: HAND FINISHING THERMOFORMING		
3.0	THERMOFORMING	THERMOFORMING MACHINE
 Comment: THERMOFORMING MACHINE		

1) Cut Blanks

08/07/16 X/10

BB

Pto

Thermoform as per Dwg. D32811and Folio FTA 009

Dwg. Rev. D,

Folio Rev. _____

08/07/17 X 10

BB

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



08/07/17 X

BB

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3281-3 PAR #: N/A Fault Category: Prod. Item missing NCR: Yes No DQA: S Date: 08/07/22
 QA: N/C Closed: D Date: 08/07/22

NCR: 40474		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/22	3.0	one part scrap . operator formed Panel with the wrong side up. Re operator error he didn't notice the texture before he formed it. upside down	J 08/07/22	Scrap and Destory to replace	B 08/07/22	S 08/07/22	/	S 08/07/22

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:13:59 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR AFT LH

Job Number: 40474

Part Number: D32813

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/07/21 X9

6.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 08/07/21 X9

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BB 08/07/21 X9

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

P 08/07/21 X9

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/21 X9

Job Completion



MF 08-07-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40474
Description: Floor Protector, Aft LH	Part Number:	D3281-3
Inspection Dwg: D3281 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/07/17

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.18	✓			
17.1	+/-0.100	17.125	✓			
14.3	+/-0.100	14.3	✓			
0.95	+/-0.030	.95	✓			
0.25	+/-0.030	.247	✓			
3.1	+/-0.100	3.125	✓			
0.050	Min	.61	✓			
0.070	+/-0.010	.80	✓			

Measured by: BB

Date: 08/07/17

Audited by: DL

Date: 08.07.17

Prototype Approval: N/A

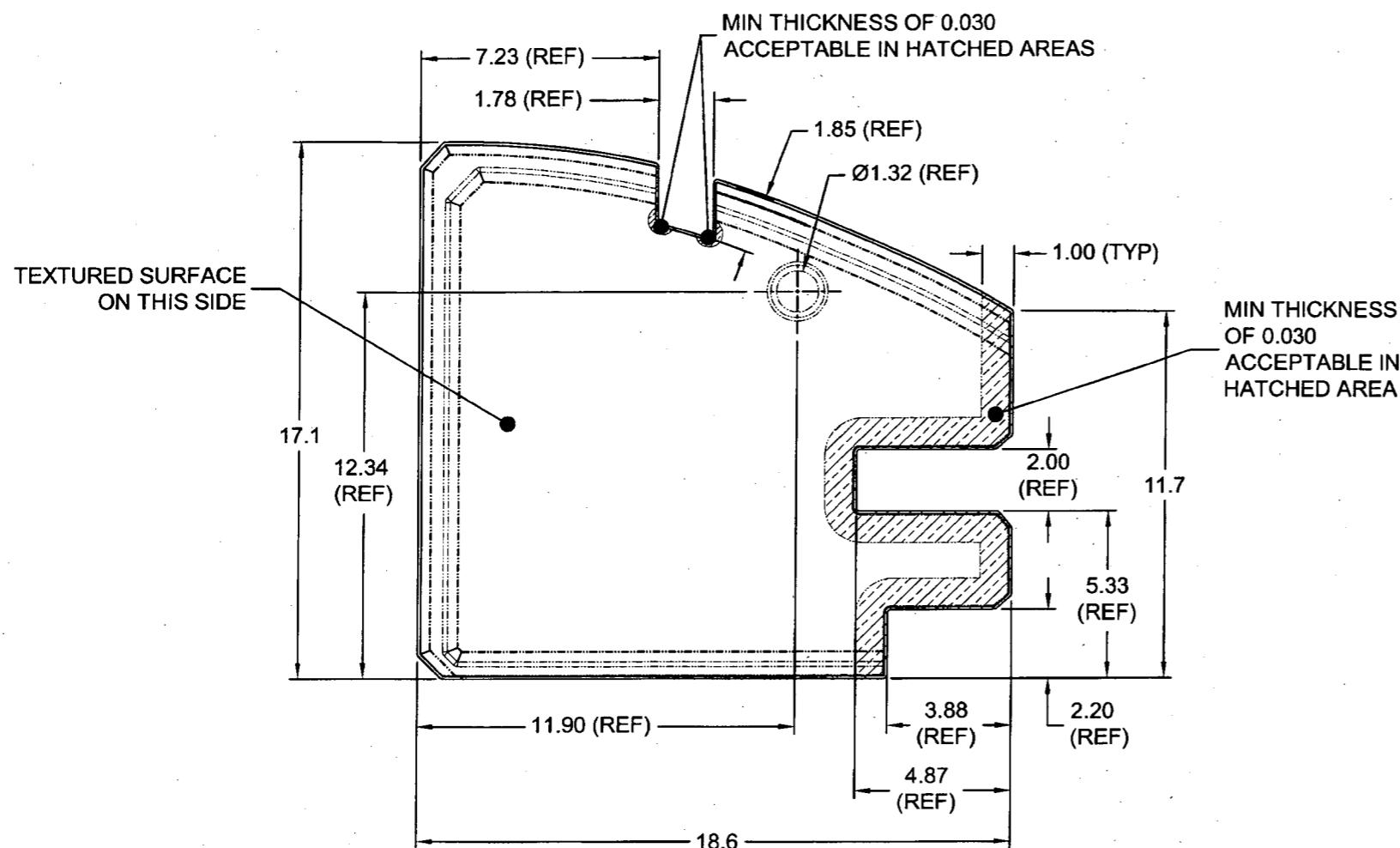
Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	BB

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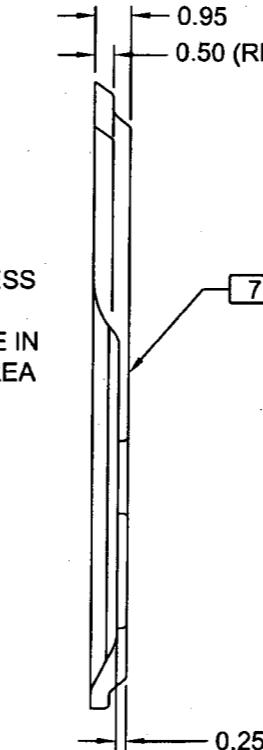
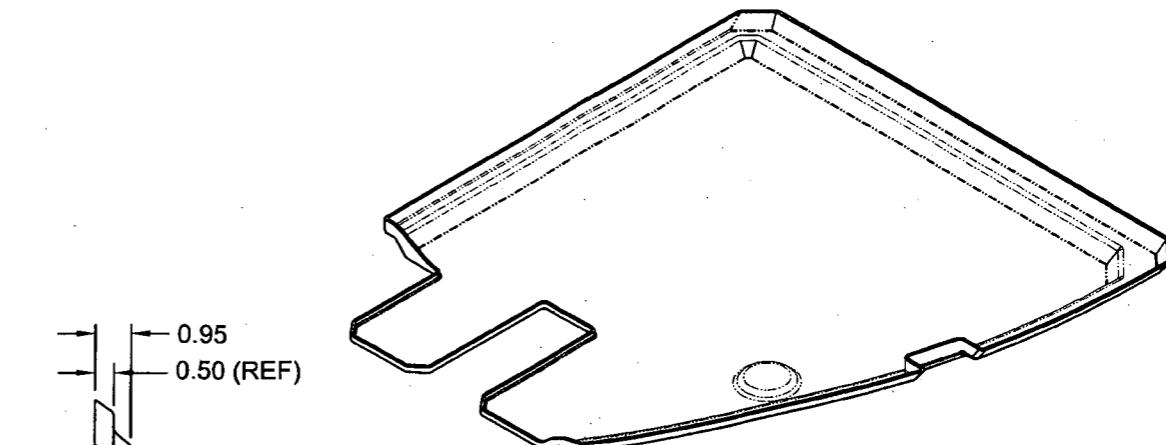
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D3281-1 FLOOR PROTECTOR

D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.95 lb



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D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	9P	DART AEROSPACE LTD	
DRAWN	P4	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO.	REV. D
MFG. APPR.	DP	D3281	SHEET 1 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	CH	FLOOR PROTECTOR	NTS
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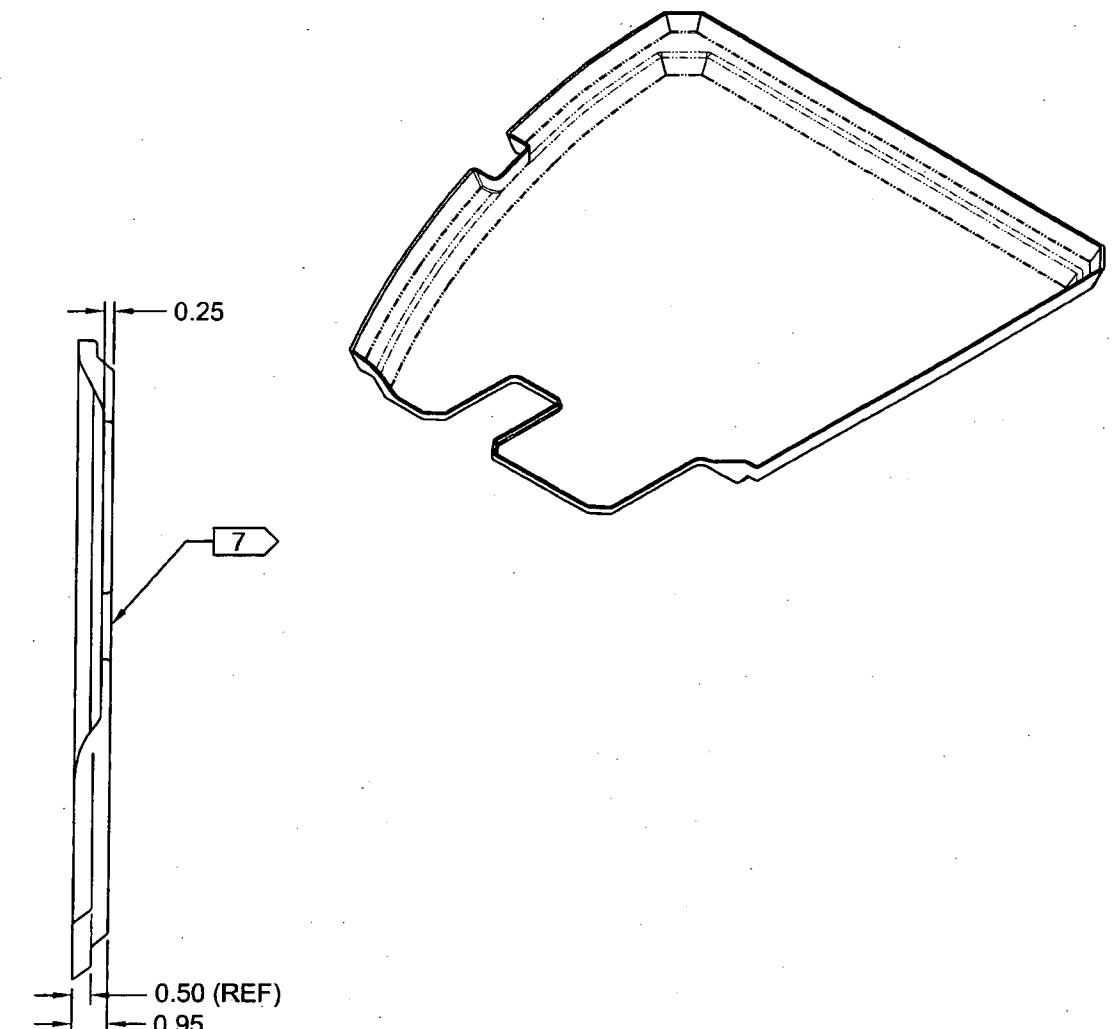
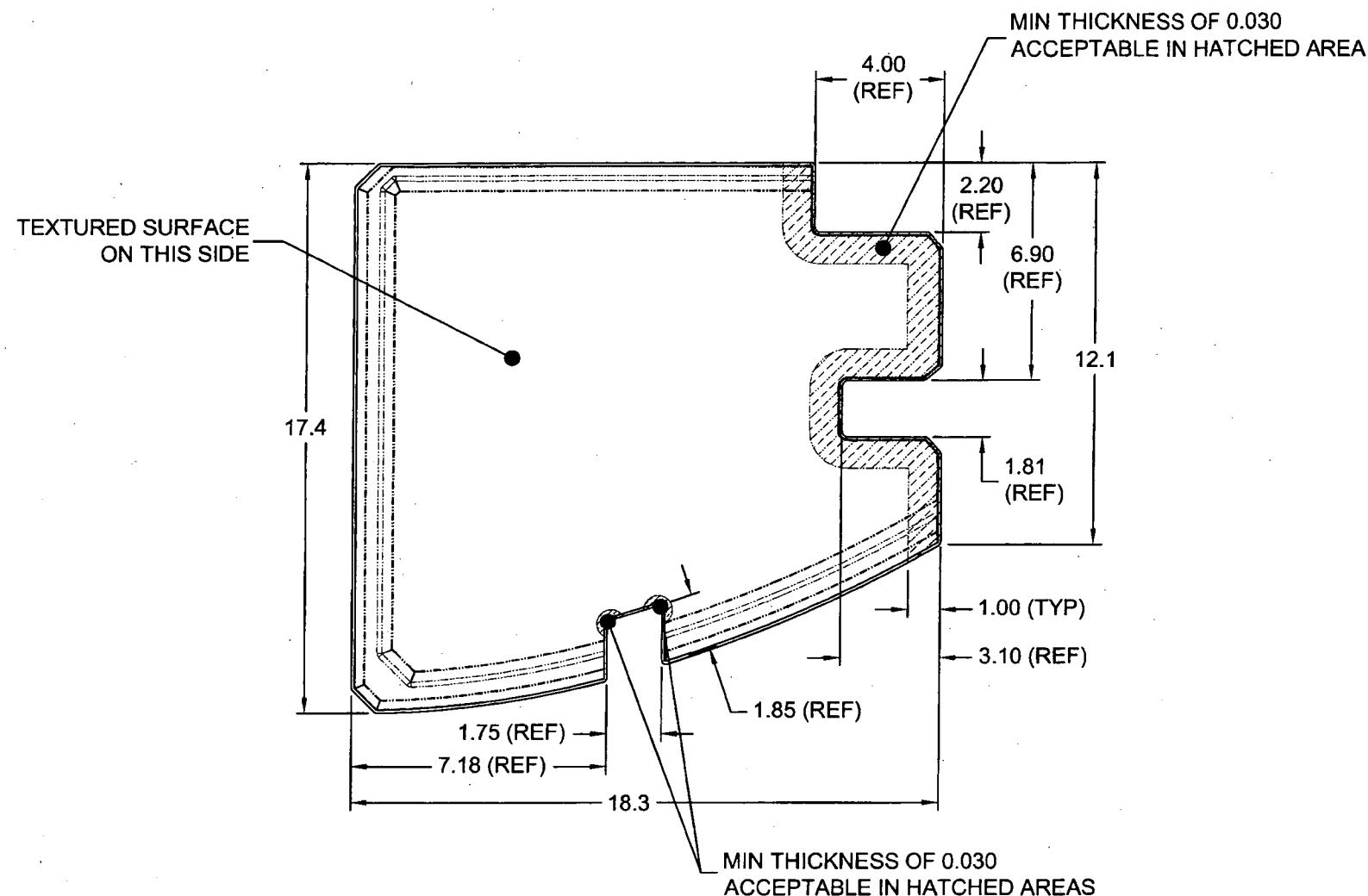
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D3281-2 FLOOR PROTECTOR

D3281-2 NOTES:

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006; BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.97 lb

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CHECKED		DRAWING NO.
MFG. APPR.		REV. D
APPROVED		D3281
DE APPR.		SHEET 2 OF 4
DATE	08.03.28	TITLE
		SCALE
		FLOOR PROTECTOR
		NTS
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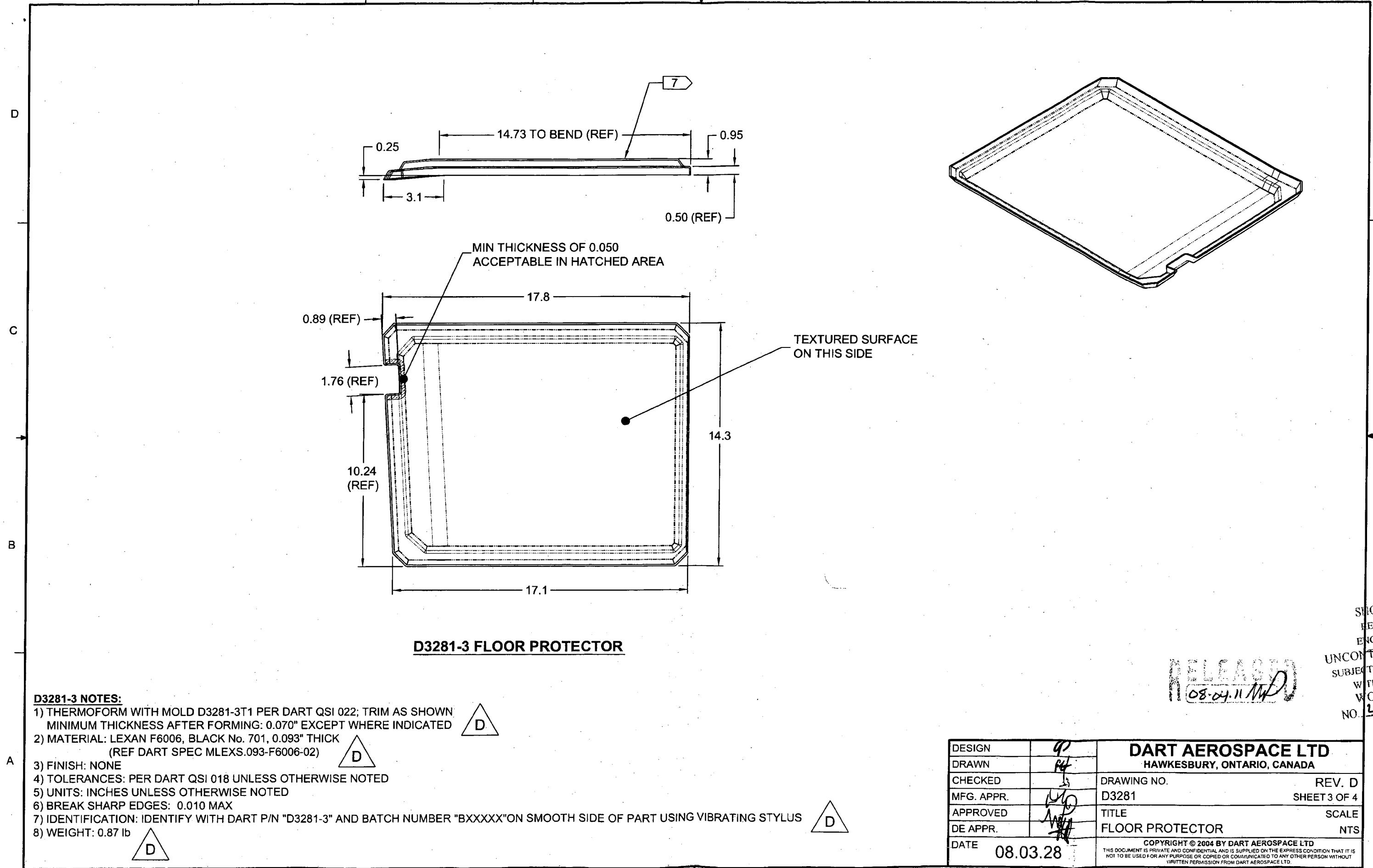
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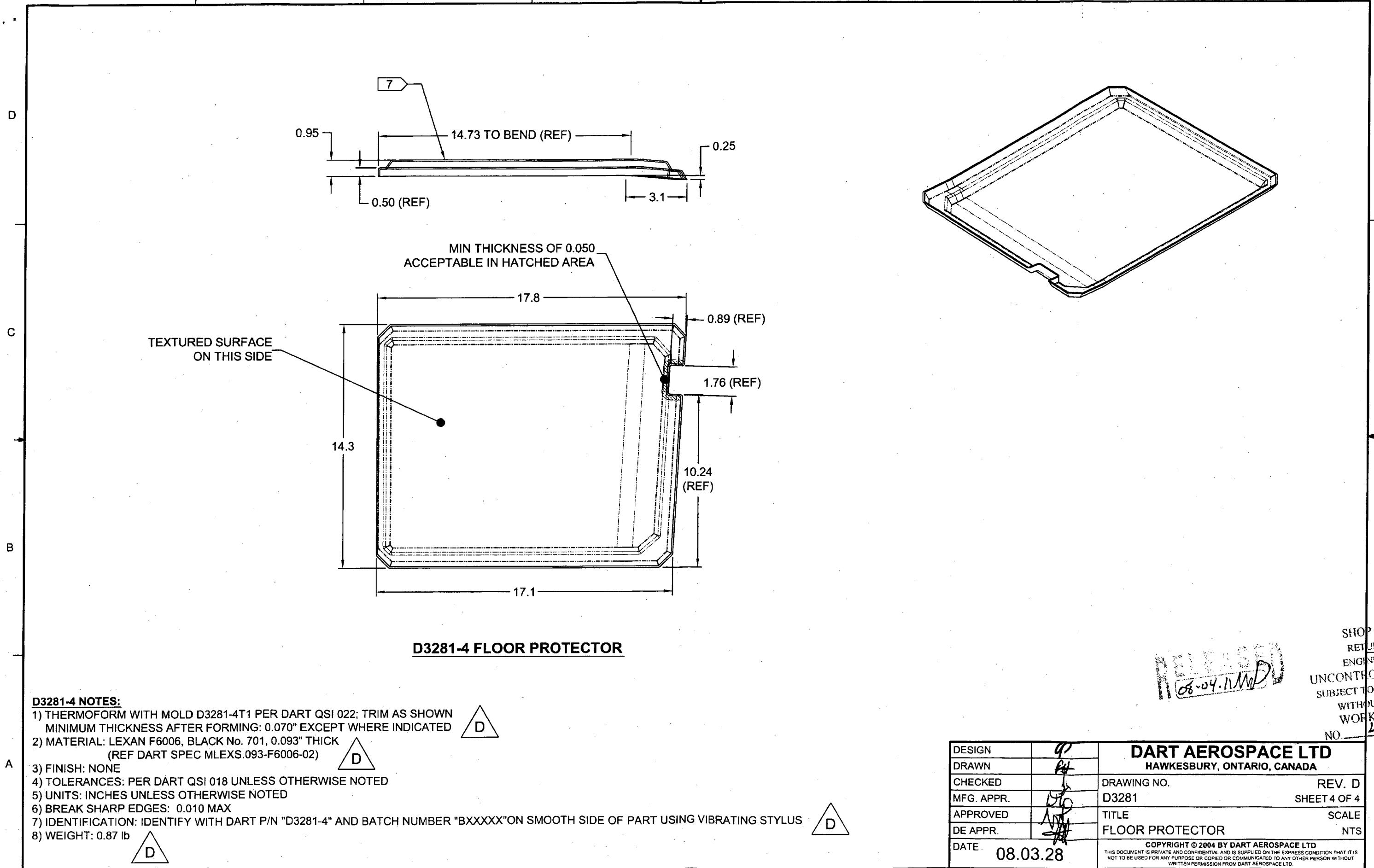
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DESIGN	92	DART AEROSPACE LTD
DRAWN	PL	HAWKESBURY, ONTARIO, CANADA
CHECKED	1	DRAWING NO. REV. D
MFG. APPR.	DC	D3281 SHEET 4 OF 4
APPROVED	AM	TITLE
DE APPR.	AM	SCALE
DATE	08.03.28	FLOOR PROTECTOR NTS

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